

24152

DART AEROSPACE LTD		Work Order: <del>23883</del>
Description: <i>Net Plate Assembly</i>		Part Number: D2872-045
Dwg: D2872		Qty: <del>20</del> 29
		Page of

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	W	0508/30	30
2	MU	Cut Blanks: .750" x .375 x 2.700" Long Mat: 6061-T6 QQ-A-200/B OR QQ-A-225/B 1 (M6061T6B .750 x .375) Batch: 118237	W	0508/31	30
3	MU	Machine as per folio 549 of Dwg D2872	J	0509/02	29
4	QC2	Inspect Parts as they come off	J	0509/02	29
5	QC3	Second Check	BC	05-08-02	29
6	QA	Debur	J	0509/02	29
7	QA	C'Sink as per Dwg D2872	ml	05-09-09	29
8	QC5	Inspect Work to Step # 7	J	05-09-12	29
9	FP	Chemical Conversion as per Part QSI 005 4.1.	ml	05-09-19	29
10	QC3	Inspect Chemical Conversion	SB	05/09/20	29

Rev	Date	Change	Revised By	Approved

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: PS Date: 05/09/22

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler			
7A	GA	Pick:			
		Off Part# Desc Batch			
		2. MS21086LS Nut Plate M 18134	SB	05/09/20	29
		4. MS2042LAD4-5 Rivet M 30122			
		Example on pin Ray D287.2			
12	DCS	Inspect Work to Step # 11,	J	05-05-21	29
13	ST	Identify: Stack.	DL	05/09/21	29
14	AC	Cast/Part. 10, 14 10, 14	Syc	05-09-22	29
15	DC	Close w/o Level 21	DP	05/09/22	29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Aug 30, 2005  
11:06 am

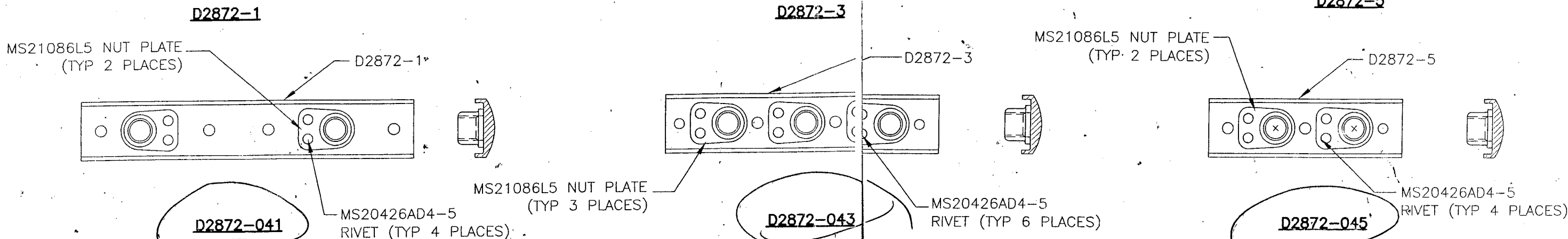
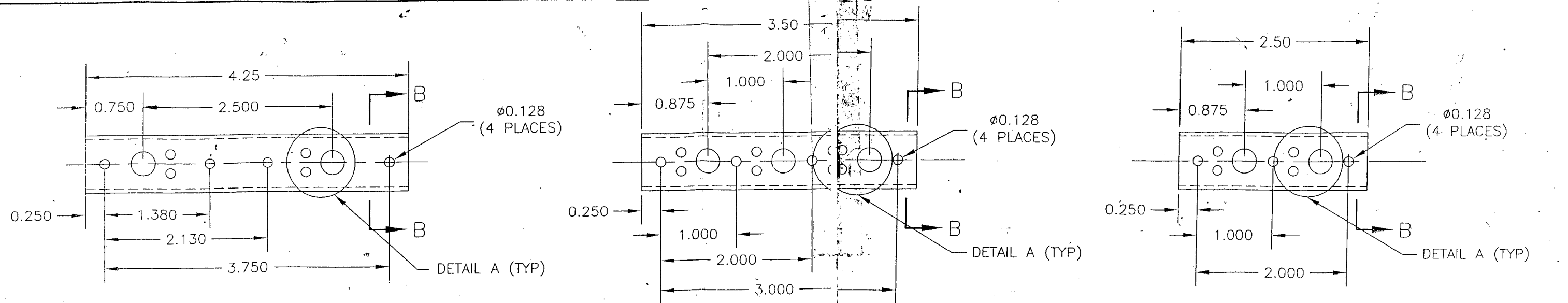
Work Order No : 0024152  
Project Name : D2872-045  
Project For : WK536  
Work Order Type : Main  
Main WO Number :  
House Part Number : D2872-045  
Description : Nut Plate Assembly  
Manufactured : Yes  
Amount Req'd : 20  
Amount Done : 0  
Start Date : 08-30-05  
Est Finish Date : 09-08-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00





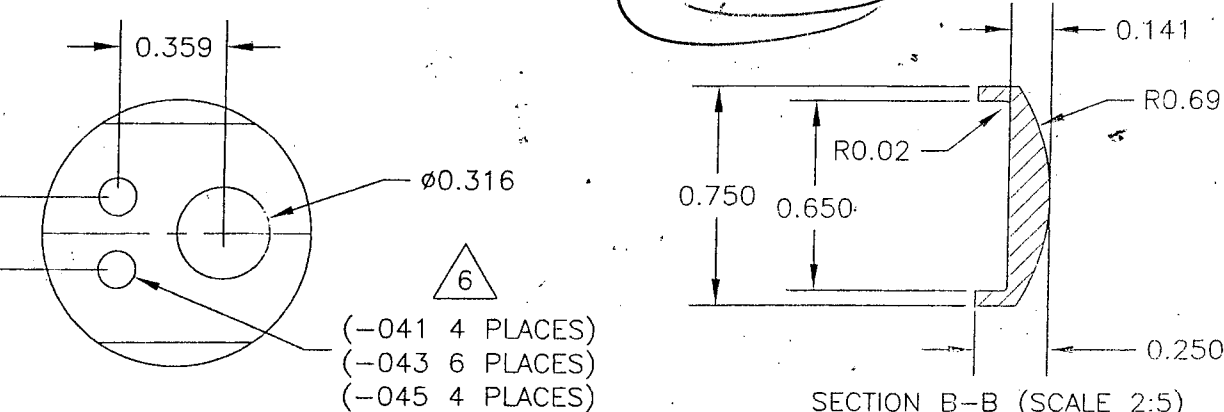
- D2872-1/-3/-5 RADIUS BLOCK**
- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B0.750X0.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B0.750X0.250)
  - 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
  - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) ALL DIMENSIONS ARE INCHES
  - 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
  - 6)  $\phi 0.128$  PILOT + C'BORE CURVED SIDE  $\phi 0.230 \times 0.050$  DEEP + C'SINK CURVED SIDE  $\phi 0.225 \times 100$

**D2872-041/-043/-045 NUT PLATE ASSEMBLY**

- 1) INSTALL MS21086L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-5 RIVETS

**D2872-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST**

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2872-041	NUT PLATE ASSEMBLY
	X		D2872-043	NUT PLATE ASSEMBLY
		X	D2872-045	NUT PLATE ASSEMBLY
1			D2872-1	RADIUS BLOCK
	1		D2872-3	RADIUS BLOCK
		1	D2872-5	RADIUS BLOCK
4	6	4	MS20426AD4-5	RIVET
2	3	2	MS21086L5	NUT PLATE



DETAIL A (SCALE 2:5)

CONTROLLED COPY

RELEASED 05.07.26

A	05.07.26	NEW ISSUE
DESIGN PH	DRAWN BY PH	DART DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED DS	APPROVED DS	DRAWING NO. D2872
DATE 05.07.26	TITLE RADIUS BLOCK	REV. A SHEET 1 OF 1

